

Work Order ID 79794

79794

Page 1

February-03-12 10:23:37 AM

Item ID: D3183-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 03/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/03 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3183	Rev C1

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00 OK 12/02/19 4 0
 Jeaspa Bandsaw Cut blanks: (1.500" x 2.250") 5.500" long

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00 OK 12/03/02 4 0
 HAAS CNC vertical machine #1 1-Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-42-Debur3-Scribe batch number

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 OK 12/03/03 4 0
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12-03-05		(4)			
140 *140* Small Fab Small Fab	Small Fab Memo Assemble D3183-043 as per Dwg D3183.	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/2/03/06		(4)			

4/12/03/06 (4)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>235B</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

012-03-4
(4)

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Picklist Print

February-03-12 10:23:40 AM

Page 1

Work Order ID: 79794

79794

Parent Item: D3183-044

D3183-044

Parent Item Name: Bracket Assembly

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-045 *D3183-045* Bearing Assembly		Manufactured	No			100	Each	8.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST236				8					
					77830			8					
D3121-21 *D3121-21* Bolt		Manufactured	No			140	Each	30.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235				30					
				66969				1					
				74546				3					
				76176				26					
M174B1.500X02.250 *M174B1 500X02 250* 17-4 SS Bar 1.50 X2.250		Purchased	No			140	f	17.9279	0.4583	1.929684			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT031				17.9279					
				108309				1.08					
				113568				11.8333					
				115806				5.0146					

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Ep 12/03/06
B 79697 (80)

Ep 12/03/06
B 79732 (80)

1.93 m 12/02/19

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DART AEROSPACE LTD		Work Order:	79794
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.190	—		R-b	
R0.063	+/-0.010	R.063	—		"	
0.182	+/-0.010	.183	—		Vern ML-06	
0.070	+/-0.010	.067	—		"	
0.100	+/-0.010	.100	—		"	
Ø0.201 x 0.100	+/-0.010	Ø.201 x .100	—		"	
0.182	+/-0.010	.182	—		"	
5.32	+/-0.030	5.325	—		"	
5.036	+/-0.010	5.036	—		"	
2.120	+/-0.010	2.120	—		"	
1.290	+/-0.010	1.290	—		"	
0.365	+/-0.010	.365	—		"	
0.218	+/-0.010	.215	—		"	
1.030	+/-0.010	1.030	—		"	
1.90	+/-0.030	1.900	—		"	
1.012	+/-0.010	1.011	—		"	
Ø0.201 x 0.100	+/-0.010	Ø.201 x .100	—		"	
0.786	+/-0.010	.780	—		"	
Ø0.392	+0.002/-0.000	Ø.3937	—		"	
R0.19	+/-0.030	R.190	—		R-b	
3.954	+/-0.010	3.954	—		Vern ML-06	
0.162	+/-0.010	.164	—		"	
R0.19	+/-0.030	R.190	—		R-b	
R0.25	+/-0.030	R.250	—		R-b	
4.26	+/-0.030	4.260	—		Vern ML-06	
2.800	+/-0.030	2.770	—		"	
Calculated dimension	+/-0.030	2.770	—		"	
0.162	+/-0.010	.162	—		"	
0.615	+/-0.010	.610	—		"	
0.435	+/-0.010	.432	—		"	
0.200	+/-0.010	.201	—		"	
0.381	+/-0.010	.375	—		"	
0.032	+/-0.010	.031	—		"	

Measured by: <u>OR</u>	Audited by: <u>SL</u>	Preliminary Approval:	N/A
Date: 12/03/03	Date: 12-03-05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	AI

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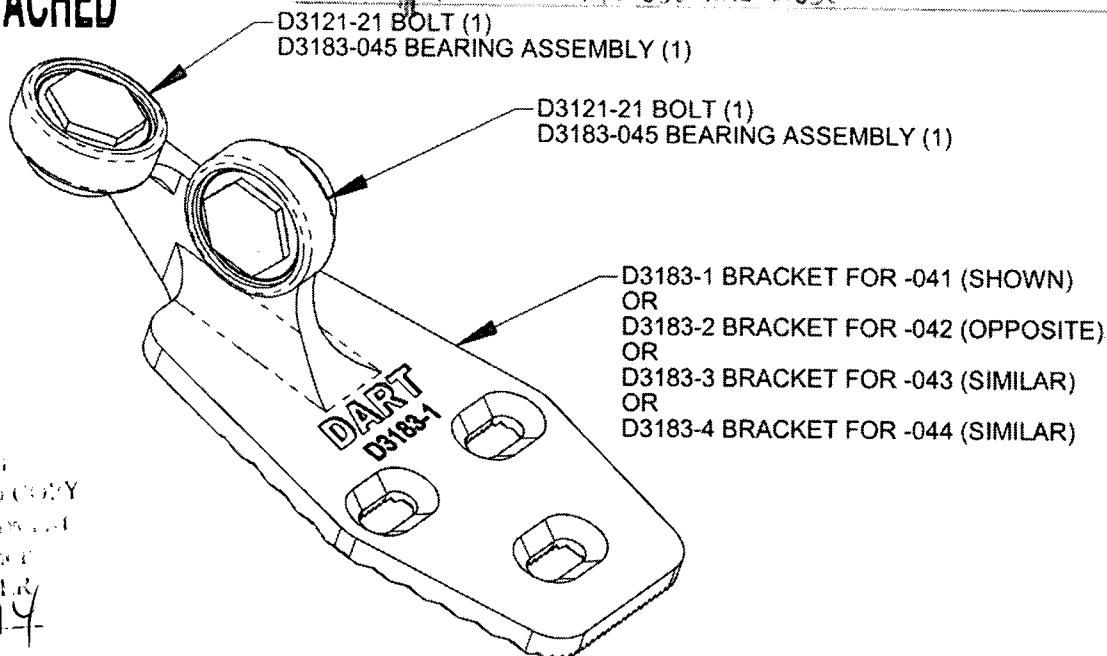
NOTE: Date & initial all entries



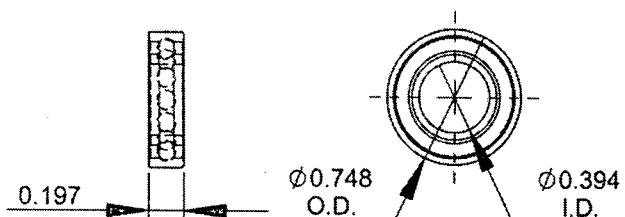
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01
DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER
NO. 79794

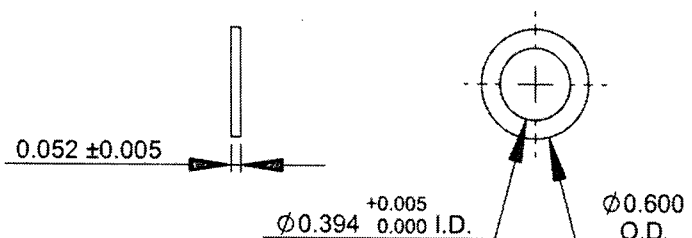


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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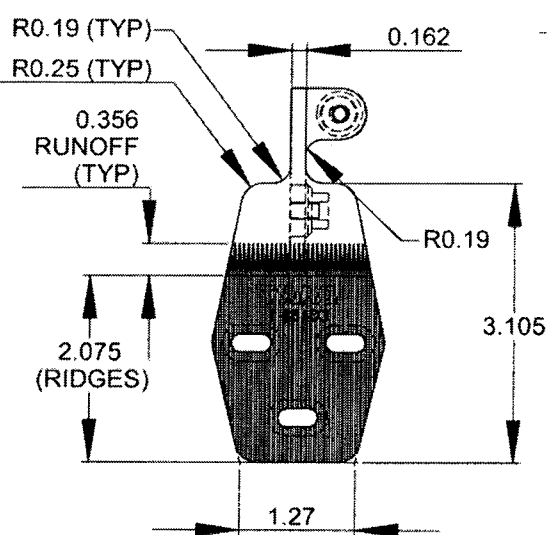
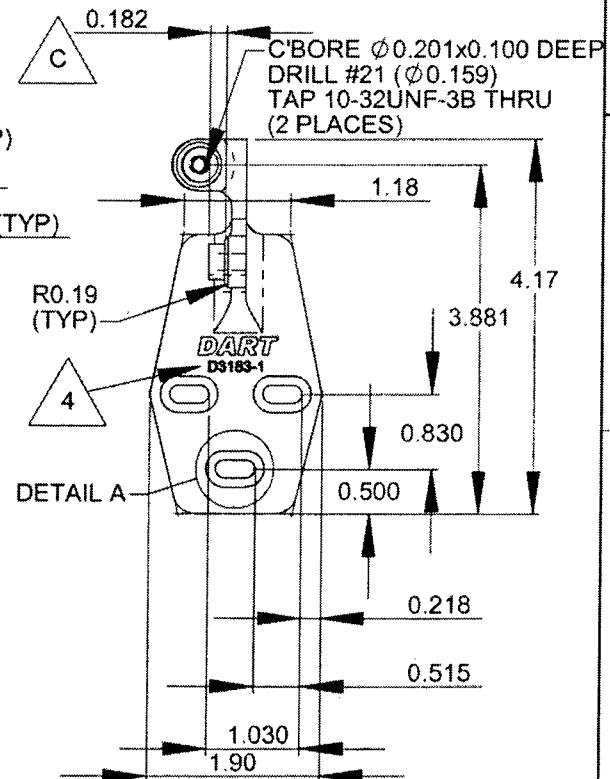
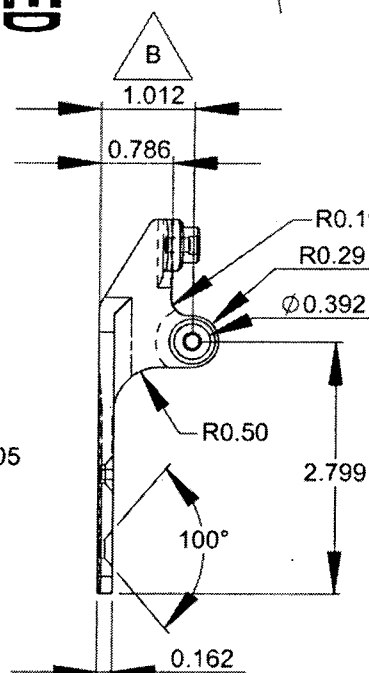
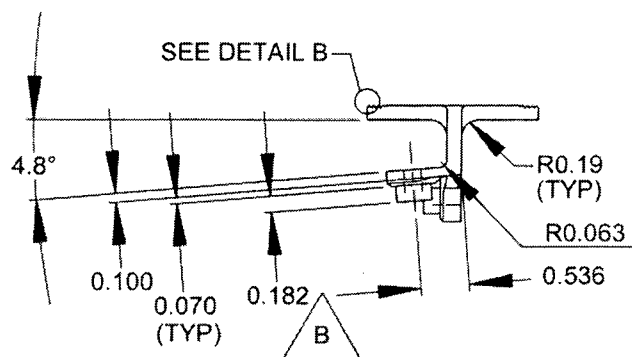
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART Aerospace Ltd
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
04.02.17	D3183	SHEET 2 OF 4
	BRACKET ASSEMBLY	SCALE 1:2

RELEASED
04-03-01



DEO ATTACHED

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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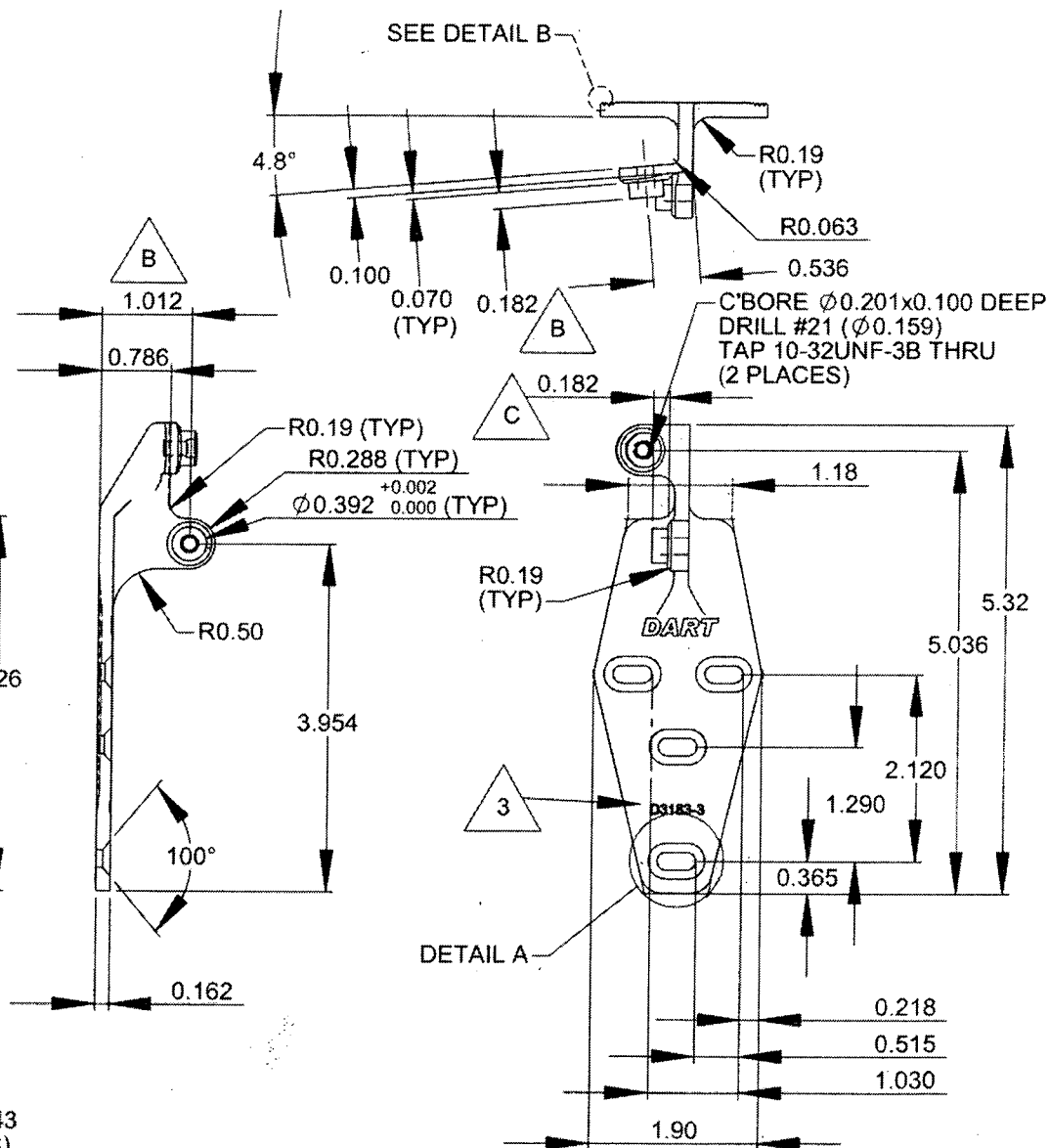
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		13M20						

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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2

299794



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DEO ATTACHED
RELEASED
04.03.01

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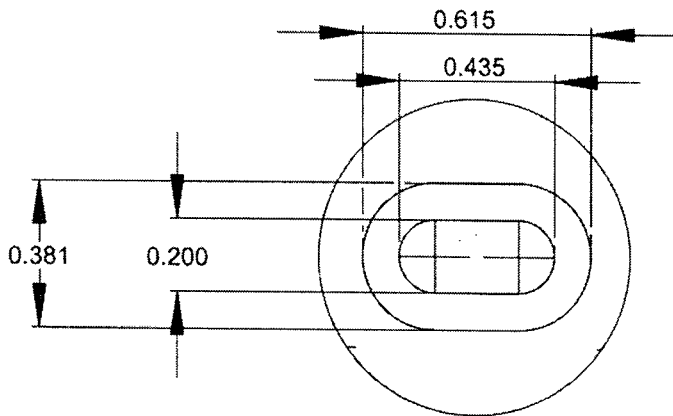
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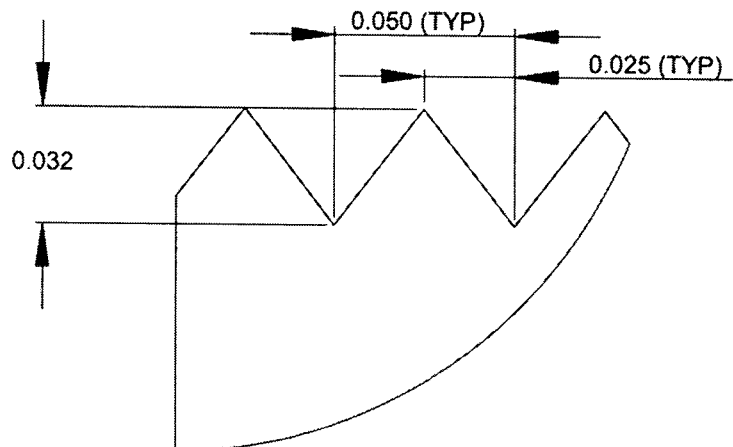
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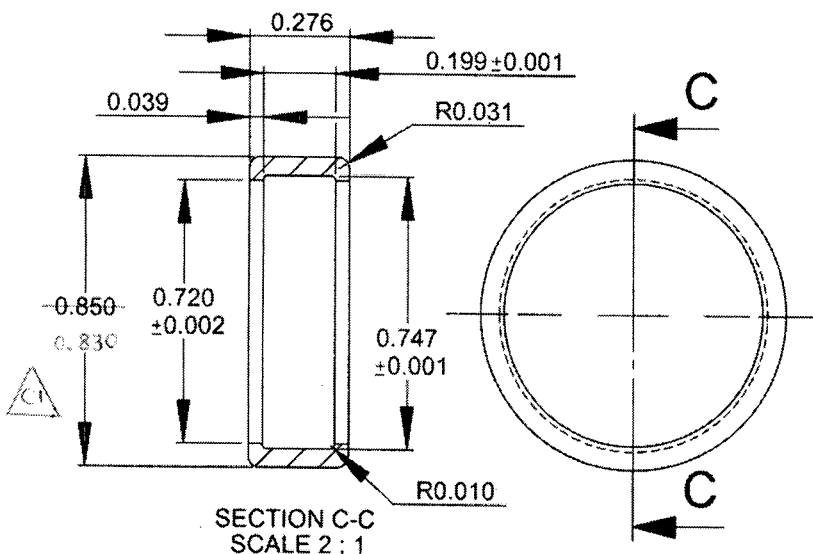
DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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Dart Aerospace Ltd

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